

**Work Order ID 63885**

Thursday, November 18, 2010 9:25:11 AM



Page 1

Item ID: D4274-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Plate, Aft Support

Start Date: 11/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-11-18

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	MATERIAL CERTIFICATION					
D4274	PA1	REQD UPON DELIVERY <i>10-11-18</i>					

100

0.00



Waterjet

Memo

FLOW CNC Waterjet

*304 178*

1-Cut as per Dwg

Dwg Rev: PA1Prog Rev: PA1

2-Deburr if necessary

*10-11-18**(4)*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

*10-11-18*

**Work Order ID 63885**

Page 2

Thursday, November 18, 2010 9:25:11 AM

Item ID: D4274-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Plate, Aft Support

Start Date: 11/18/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00 - inspected to P21  
Day only

0.00 11/18/10 (4)



QC

Quality Control

130

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Memo

0.00

D 10-11-10 (4) \_\_\_\_\_

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

H test Rev P21 Rev A/H  
10-11-23

ACTIVE RECALL

ACTIVE 10-11-10 AUTH

RELEASED \_\_\_\_\_

DATE \_\_\_\_\_

MF 10-11-30

# Picklist Print

Page 1

Thursday, November 18, 2010 9:25:10 AM

Work Order ID: 63885



Parent Item: D4274-3



Parent Item Name: Plate, Aft Support

Start Date: 11/18/2010

Required Date: 11/19/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased		No		100	sf	39.8523	0.357	1.503158		<u>10-11-18</u>	

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT	39.8523	
114799	39.8523	<u>114799</u>

(4)

DART AEROSPACE LTD

Work Order: 63885

Description: PLATE AFT SUPPORT

Part Number: D4274-3

Inspection Dwg: D4274-3, Rev: P41

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

 First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.132	✗		✓	1802
Ø .191	+ .064 - .001	.193	✗		✓	
Ø .53	+ .012 - .001	.530	✗		✓	
2.86	+ .30	2.801	✗		✓	
1.05	+ .30	1.057	✗		✓	
.60	+ .30	.603	✗		✓	
1.20	+ .30	1.207	✗		✓	
1.10	+ .30	1.091	✗		✓	
.75	+ .30	.750	✗		✓	
3.000	+ .010	2.994	✗		✓	
1.500	+ .010	1.498	✗		✓	
2.300	+ .010	2.293	✗		✓	
.36	+ .30	.361	✗		✓	
.792	+ .00	.792	✗		✓	
.672	+ .00	.662	✗		✓	
.464	+ .010	.457	✗		✓	
.70	+ .30	.697	✗		✓	
.68	+ .30	.681	✗		✓	
.38	+ .30	.379	✗		✓	
1.123	+ .010	1.122	✗		✓	
1.983	+ .010	1.977	✗		✓	
.991	+ .010	.987	✗		✓	

Measured by:	PS
Date:	10-11-18

Audited by:	S
Date:	10/11/18

Prototype Approval:	NP
Date:	-

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order: 63885
Description: PLATE ACT SUPPORT	Part Number: D4374-3
Inspection Dwg:D4374-3 Rev: PA1	Page 1 of 1

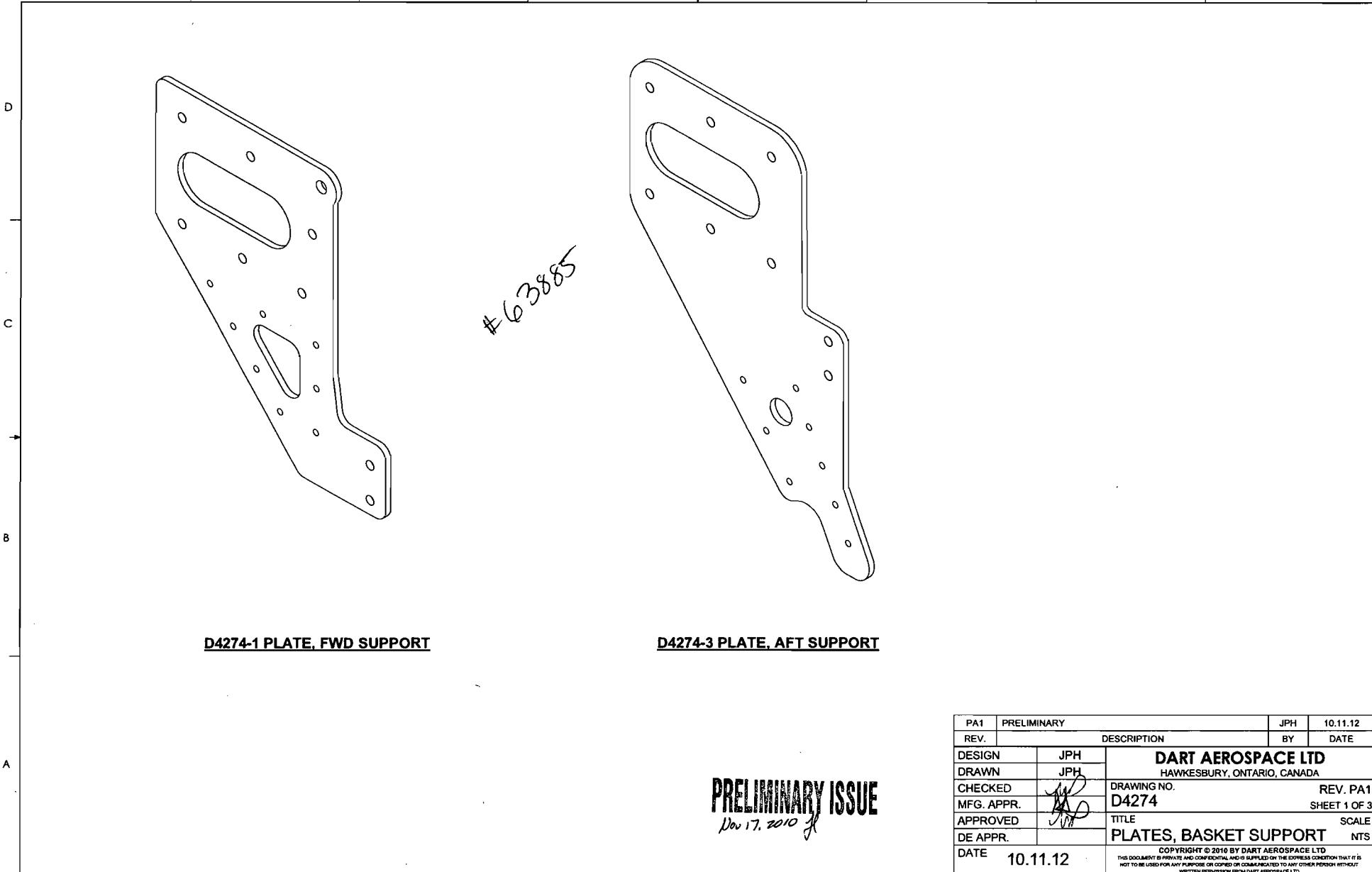
## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      X Prototype

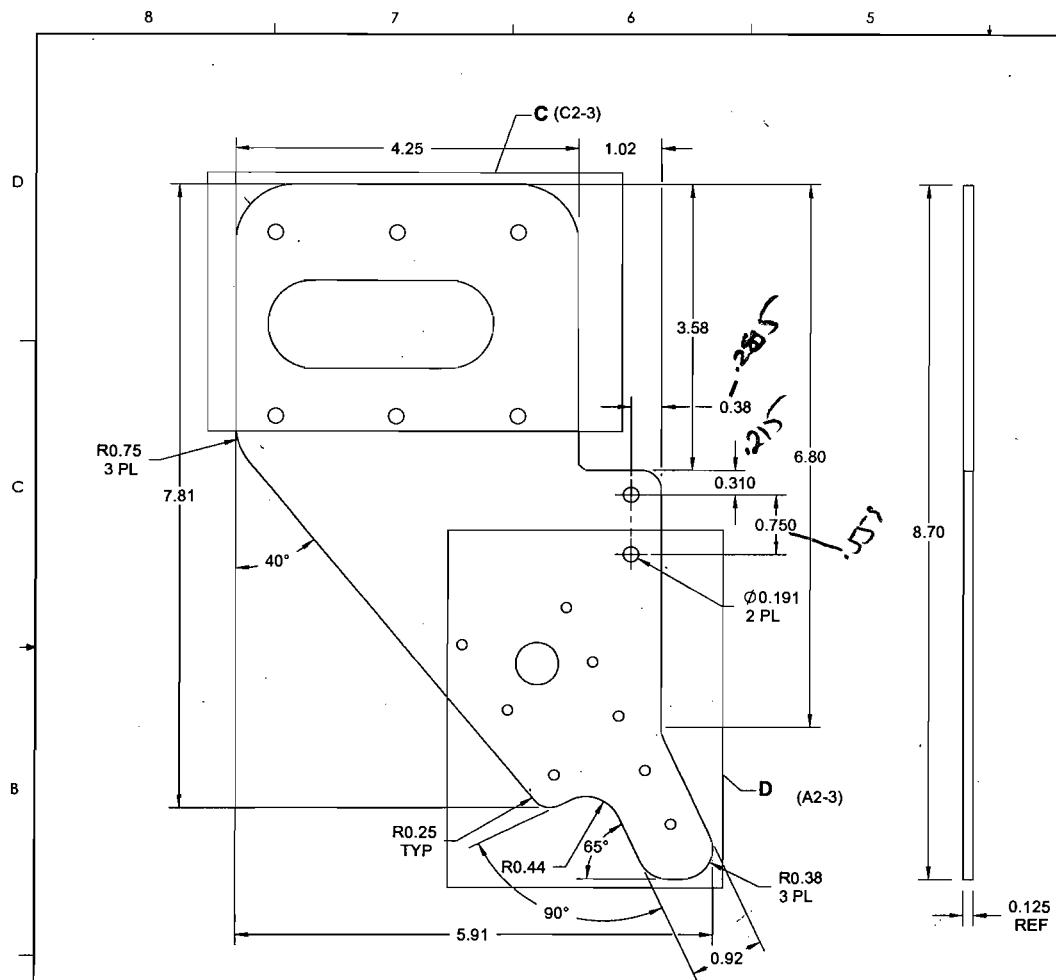
Measured by: <u>PS</u>	Audited by: <u>S</u>	Prototype Approval: <u>NA</u>
Date: <u>10-11-18</u>	Date: <u>10/11/18</u>	Date: <u>—</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



PA1	PRELIMINARY	JPH	10.11.12
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4274	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
DATE	10.11.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

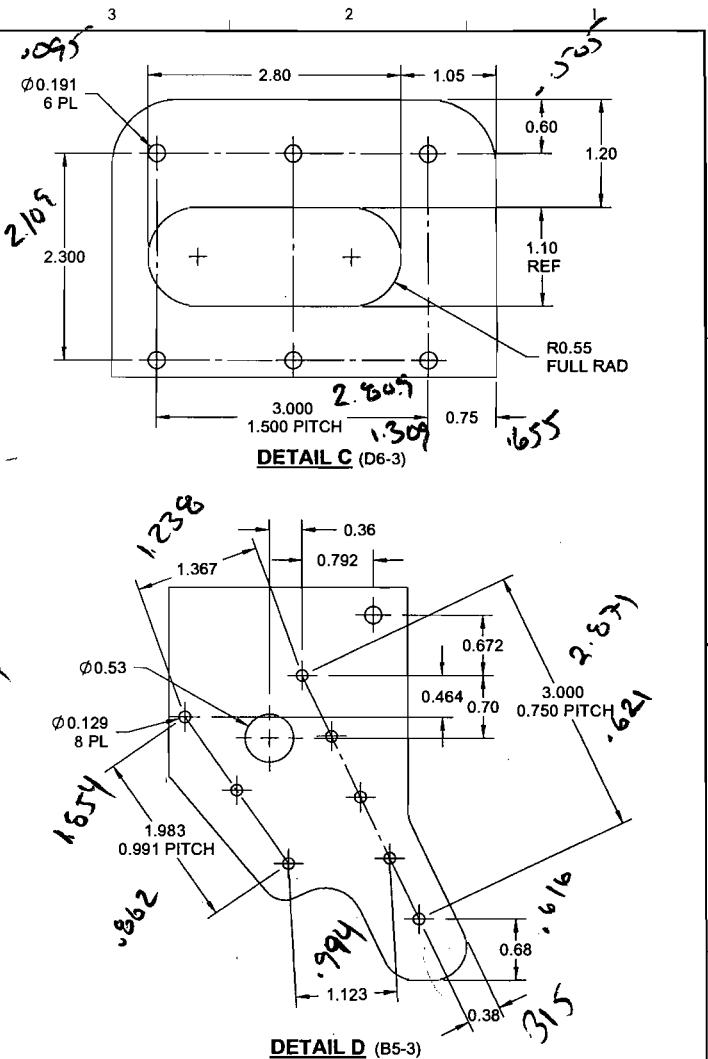


D4274-3 PLATE, AFT SUPPORT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.94 lbs

PRELIMINARY ISSUE  
Nov 17, 2010 fl.



DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4274	
MFG. APPR.		REV. PA1	
APPROVED		SHEET 3 OF 3	
DE APPR.		TITLE PLATES, BASKET SUPPORT	
DATE 10.11.12		SCALE NTS	

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## Receiving Report

Date: 10/03/01

Batch No: M114785

Supplier: MAGNA

Dart P/O: 11923

Packing Slip: Yes  No   
 Invoice: Yes  No   
 Receipt: Cash  Cr

Release Note Attached: Yes  No  N/A   
 Waybill Attached: Yes  No  N/A   
 Shipment Complete: Yes  No  N/A   
 QC6 Inspection  N/A   
 Work Order  N/A

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) SD Level 12 SD

Production/Admin:

Date 10/03/01

Location  

Received/Costing

Initial

## Purchase Order Receipt Listing

Page 1 of 1

May 31, 2010 8:13:15 AM

All amounts are calculated in domestic currency.

All Vendors PO ID po11973 Receipt Dates from 5/31/2010 to 5/31/2010 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID	Vendor Name	VC-MAG002	Magna Stainless								
PO11973	1	M304S16GA	sf		5/31/2010	5/31/2010	128.0000	\$5.03	0.0000	0	\$643.20
CAD	No	304/316 Sheet .063	sf	114799		128.0000	DCUSER		\$643.20	0.0000	0
	2	M304S11GA	sf		5/31/2010	5/31/2010	128.0000	\$10.47	0.0000	0	\$1,340.16
	No	304/316 0.125 Sheet	sf	114799		128.0000	DCUSER		\$1,340.16	0.0000	0
	3	M6061T6S.050	sf		5/31/2010	5/31/2010	128.0000	\$2.88	0.0000	0	\$368.00
	No	6061-T6 .050 Sheet	sf	114799		128.0000	DCUSER		\$368.00	0.0000	0
											Total Received Quantity: 384.0000
											Total Qty to Inspect (PO U/M): 0.0000
											Total Reject Quantity: 0.0000
											Total Receipt Value: \$2,351.36
											Total Balance Due Quantity: 0.0000

**SOLD TO:**  
 DART AEROSPACE LTD  
 1270 ABERDEEN STREET  
 HAWKESBURY, ON K6A 1K7

**SHIP TO:**  
 DART AEROSPACE LTD  
 1270 ABERDEEN STREET  
 HAWKESBURY, ON K6A 1K7

**SPECIAL INSTRUCTIONS**

M \*\*\*\*STOCK\*\*\*\*

Contact: CHANTAL LAVOIE

Ship Terms: PREPAID

MTR:Y

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	11973	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W030353	NET 30 DAYS	NIR:R-557065-1	05/27/10	05/31/10	05/31/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
4		PC	ALUMINUM SHEET ASH 6061 T6 .050" x 48" x 96" MATERIAL IS PER QQA 250/11 AND PER AMS 4027	92 LB / 4 PC	L037272	1615261
4		PC	STAINLESS SHEET SSH 304 2B 16ga x 48" x 96" MATERIAL AS PER ASTM A240	336 LB / 4 PC	L038199	99020048
4		PC	SSH 304 2B 11ga x 48" x 96" MATERIAL AS PER ASTM A240	672 LB / 4 PC	I037542	7281937
Skids: 1					Approx	Weight: 1,100 LB

Received by: \_\_\_\_\_

Date: \_\_\_\_\_

Signature: \_\_\_\_\_



P008553

C2993

## INSPECTION CERTIFICATE

CERTIFICATE NO.: YS-990165

CUSTOMER: MAGNA STAINLESS INC(DIV OF CANADIAN SPECIALTY METALS INC.)

INVOICE NO.: SSCAE40101TE9

CREDIT NUMBER: I700584

DESCRIPTION: STAINLESS STEEL SHEETS

S0105131

25.4 + 1.5MM  
= 0.059"

DATE: 12 MAR, 2010

P/L NO.	SIZE	PCS	N.W. (KG.)	SPEC	HEAT NO.	REFERENCE NO.
1	0.9MM X 1219MM X 2438MM	58	1214	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-01A
2	0.9MM X 1219MM X 2438MM	58	1217	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-01AB
3	0.9MM X 1219MM X 3048MM	46	1204	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-02A
4	0.9MM X 1219MM X 3048MM	46	1205	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-02AB
5	0.9MM X 1219MM X 3657MM	46	1445	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-03A
6	1.5MM X 1219MM X 2438MM	50	1757	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-04A
7	1.5MM X 1219MM X 2438MM	50	1760	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-05A
8	1.5MM X 1219MM X 2438MM	50	1756	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-06A
9	1.5MM X 1219MM X 2438MM	35	1231	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-06AB
10	2.5MM X 1219MM X 3048MM	16	1168	304-2B/PAPER	9902069YU -990 20188	YERYCA9901A-07A

## Chemical Composition

P/L NO.	C	Si	Mn	P	S	Ni	Cr	N	Cu	Mo	Y.S.(0.2%) N/mm2	T.S. N/mm2	Elongation %	Hardness HV
1	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
2	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
3	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
4	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
5	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
6	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
7	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
8	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
9	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
10	0.052	0.540	1.160	0.039	0.005	8.020	18.20	0.0270	0.2400	0.0900	309	648	53.0	177.0

Remark: 1. We hereby certify that the products described herein have been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

2. As per ASTM A240/480 standard.

3. The material described above has been detected with free irradiation.

YIEH CORPORATION LIMITED Q.C. MANAGER

2009433

C 1679

			<b>AK Steel Corporation</b> <b>Metallurgical Test Report</b> <b>Rockport Works</b> <b>Rockport, IN 47635</b>				Page 1						
							Load No. 9220693		SRN No. 9220693				
C U S T O M E R	S H I P T O					MILL ORDER NO. 241287-04B	PROCESSOR ORDER NO. S17824	BUYERS ORDER NO. S17824					
						PART NO. S 10105131	ENGLISH UNITS -PRODUCT- METRIC UNITS 1200 NOM 48.0000 X COIL						
COIL ID		PIECE	HEAT	PARENT COIL ID	NET WEIGHT		OUTSIDE PROCESSOR ID						
212487-04BA		1	7281937	0212487-04B	13,160 LBS. 5,969 KG.		P 041 548						
212487-04BB		1	7281937	0212487-04B	13,160 LBS. 5,969 KG.		P 041 549						
212487-04BC		1	7281937	0212487-04B	13,158 LBS. 5,965 KG.		P 041 550						
TOTAL COILS		TOTAL PIECES			TOTAL NET WEIGHT								
3		3			39,488 LBS. 17,912 KG.								
I=Indiv Analysis of Heat P=Product Analysis of Parent Coil <b>CHEMICAL ANALYSIS</b>													
ID	C	MN	P	S	SI	CR	NI	MO	N	CU			
L 7281937	.022	1.491	.029	.0011	.369	18.23	8.24	.23	.0330	.38			
SHIPPING DATE: 02/06/2009				REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL MATERIAL FREE OF RADIOACTIVE ISOTOPES MELTED AND MANUFACTURED IN THE USA									
<b>PRODUCT DESCRIPTION</b>													
CR SHOT TYPE 304/304L STAINLESS #2B FINISH SLIT EDGE * ASME A 240 -08 * ASME A 480 -08 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASME SA-240 SECTION II PART A (2004 ED. 2005 ADDENDA) * ASME SA-480 SECTION II PART A (2004 ED. 2005 ADDENDA) * ASME A 262 -02AEZ PRACTICE E * EW 10204: 2004 (E) TYPE 3.1 * ASTM A 666 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION IN ALL CASES * AMS 5511 H													
PARENT COIL ID	POS (P/T)	DIR (L, T, B)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. 1% OFFSET (KSI)	ROCKWELL HARDNESS TALL	ROCKWELL HARDNESS FRONT					
0212487-04B	T	T	A.S.T.M.	52.7	92.2	49.9	B 88	B 87					
*** CONTINUED ON NEXT PAGE ***													



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO11973**

Purchase Order Date 5/27/10

PO Print Date 5/27/10

Page Number 1 of 2

Order From : VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
*5/27/10 (5/27)*

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	Vendor Part Number						
1	M304S16GA	304/316 Sheet .063	5/31/10 Yes	128.00 sf	Yours ppd	\$5.0250	\$643.20
			<b>Special Inst:</b>	MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH AS PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240			
2	M304S11GA	304/316 0.125 Sheet	5/31/10 Yes	128.00 sf	Yours ppd	\$10.4700	\$1,340.16
			<b>Special Inst:</b>	AS ABOVE			
3	M6061T6S.050	6061-T6 .050 Sheet	5/31/10 Yes	✓ 128.00 sf	Yours ppd	\$2.8750	\$368.00
			<b>Special Inst:</b>	MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A- 250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209			

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 5/27/10



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO11973

Purchase Order Date 5/27/10  
PO Print Date 5/27/10

Page Number 2 of 2

Order From :

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

VC-MAG002

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal-Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

CAD

Currency

FOB

PO Total:

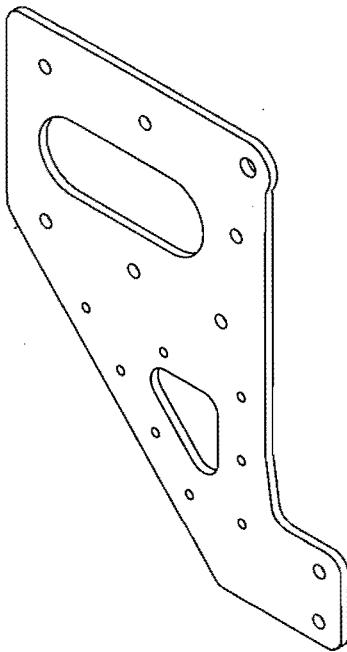
\$2,351.36

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

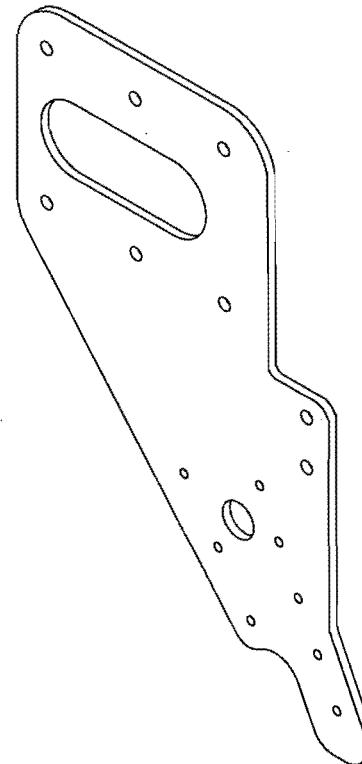
U CL  
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 5/27/10

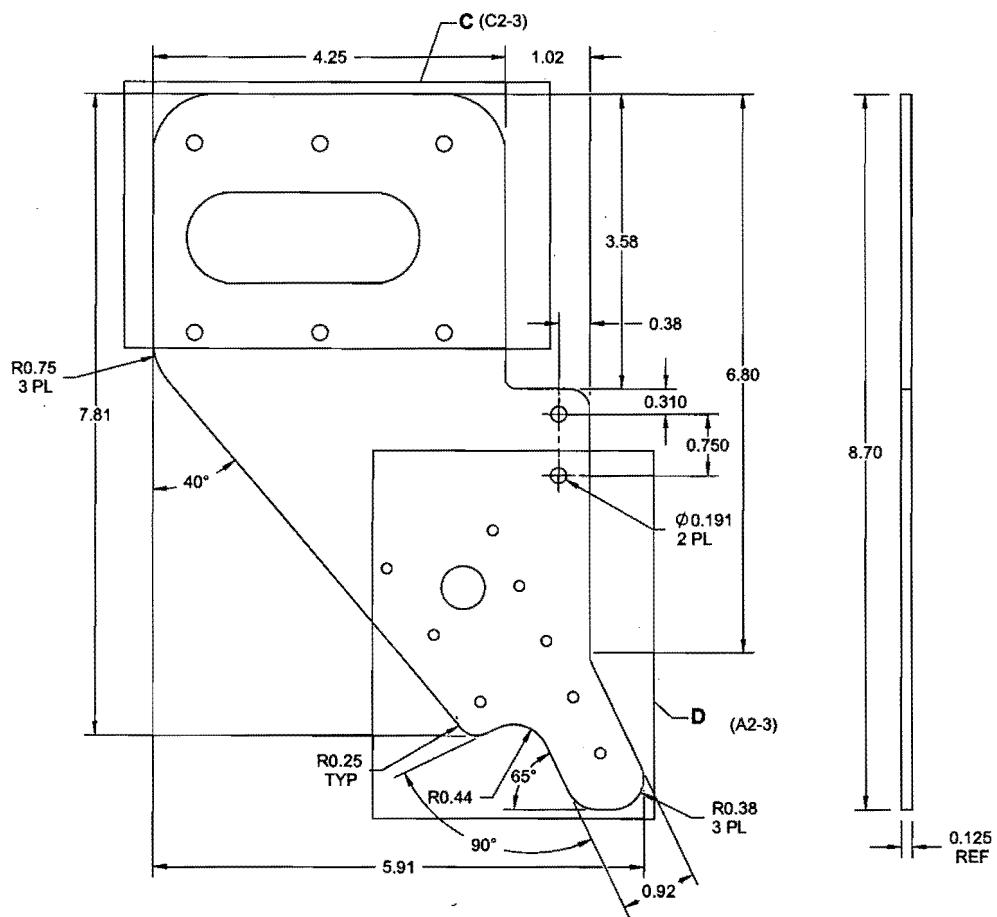


D4274-1 PLATE, FWD SUPPORT



D4274-3 PLATE, AFT SUPPORT

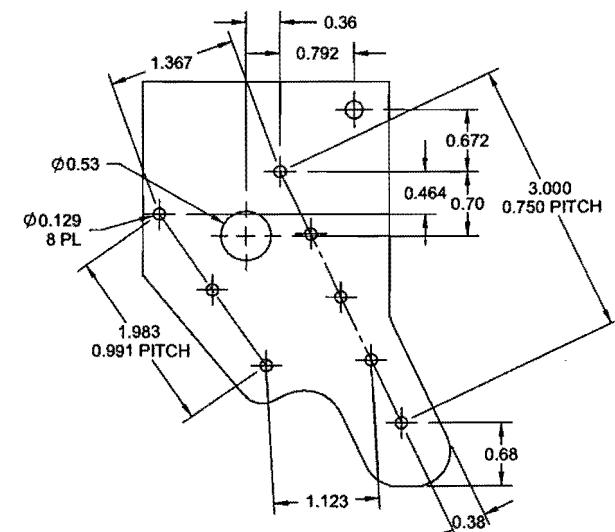
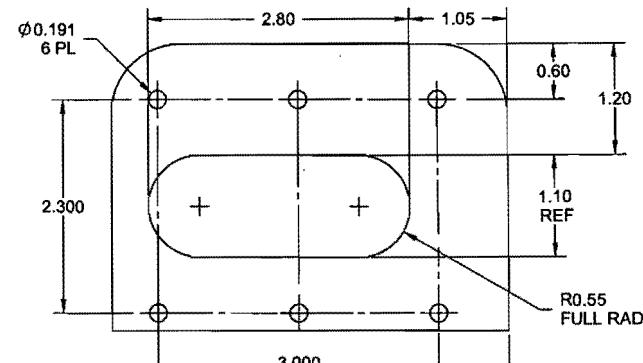
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4274	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY INFORMATION OF DART AEROSPACE LTD. IT IS RESTRICTED BY LAW FROM BEING REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4274-3 PLATE, AFT SUPPORT

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.94 lbs



DESIGN	JPH	<b>DART AEROSPACE LTD</b>
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO. D4274 REV. A
MFG. APPR.	<input checked="" type="checkbox"/>	SHEET 3 OF 3
APPROVED	<input checked="" type="checkbox"/>	TITLE PLATES, BASKET SUPPORT NTS
DE APPR.	<input checked="" type="checkbox"/>	DATE 10.11.25

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